Work Order January-07-14 3:0			*110702*								
Revision ID:	3459-3 oat Step Mounting Plate		Accept	*N900	040	100	<b>)*</b> s	etup Star Stoj	I VI	S1*	
	07/14 Start Qty: 8.00	*0** C	1	Cust Item Customer:	ID:				"N	S2*	
Approvals:	Process Plan: MC	Date: <u> 4-01-09</u>	Tooling: _ SPC (Y/N):		ate:		R	tun Star Stoj	^I\\ `	R1* R2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr										
D3459	Rev A										
100 <b>*1</b>	FLOW WATER JET  Memo		0.00				9	_ 0		JM14-02-2	Ç
FLOW CNC Waterjet	1-Cut as pe Dwg Rev:_ Prog Rev:_ 2-Deburr if	r Dwg D3459 A necessary									
110	QC2- Inspect parts off r	nachine FAI/FAIB	0.00								
*110* QC Quality Control	Мето		0.00				9	0		Jm 14-02-26	
		<b>5</b> 5									
120	QC8- Inspect parts - sec	cond check	JAS 27 9-89	1			9				
*120* oc	Memo		0.00	126							

Quality Control

DQA:			Date:										TQ AC
						<b>WORK ORDER NON</b>	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only	
   Work Orde	er:					DISPOSITION			AGAINST	DE	PARTMENT		
	•				_	Rework	Rework Skid-tube C					Water Jet	Engineering
Part N	lo.					Scrap	1		Machining Small Fab	-	Pro	d. Eng. Coor.	Quality
	•					Use-as-is	1		noforming Finishing		1	re/Packaging	Other
NCR N	lo.				<del></del>	Suspected Unapproved	]		Large Fab Composite			Supplier	
Root					Desc	ription of work order update		nitial	Action		Sign &	·-·	
Cause	ļ	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material							1						
Operator													
Offset/Setup													
Process													
Supplier													
Training													
Transport													
Unapproved			İ				<u></u>					<u> </u>	.1
		<b>.</b>				Comment	FA	ULI CA	TEGORY				
Landi		,				<b>General</b> Bend		ارمانه/ا	Program		Outside Dim	onsions [	Pressure/Forced
	_	Bending Centre No	nt Cancar	atric	-	BOM/Route	$\vdash$	Grain	riogiaili	$\vdash$	Over/Under	<del>-</del>	Set-up
	$\vdash$	Cracks	or concer	itric		Broken/Damage/Defect	$\vdash$	Hardwa	ara	$\vdash$	Part Incorre	<del> </del>	Temperature/Cure
		Crimp/Kir	ak/Binnla	Mayo	$\vdash$	Burrs	$\vdash$	4	ion Incomplete/Unqualified	-	Part Lost/M	<del> </del>	Weld
!	┝	Cuffs	ik/ kippie	, wave	⊢	Contamination	-	4 '	tions Incomplete/Unclear	$\vdash$	Part Moved	-	Wrong Stock Pulled
1	<del> </del>	Crushing			-	Countersink	$\vdash$	4	gned/off center		Positioned V	∟ Vrong	
	┢	Heat Trea			H	Cut Too Short	$\vdash$	Mislab	<del>-</del>		Power Loss/	-	Other
	_	Inspectio		Tube		Drawing		Misrea		_	J. 5115. 2530/		<u> </u>
		Marks/Ch	•			Drill Holes	$\vdash$	Off-set					
	-	1				Finish		4	Calibration				
1	Turning Sequence  Wave/Twist in Tube			Fit/Function		4	Sequence						

4												
Work Orde January-07-14				*110	702*							Page 2
Item ID: Revision ID:	D3459-3			Accept	*N900	<b>040</b>	100	)*	Setup			S1*
Item Name:	Float Step N	Mounting Plate								Stop	*N!	<b>S2*</b>
Start Date: Required Date:	1/07/14 1/07/14	Start Qty: 8.00 Req'd Qty: 8.00	*8*		Cust Item I Customer:	D:						
Reference:										<b>a</b>		
Approvals:	Process I	Plan:	Date:	Tooling:	Da	ate:			Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description	· · · · · · · · · · · · · · · · · · ·	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qty		Reject Number	Insp. Stamp
130		Identify as per dwg & Stock	k Location: <u>W403</u>	0.00								
*130* Packaging Packaging		Memo *** STOCK IN	N STEP CELL***	0.00				<u> </u>	<u>   </u>	75-96	, PD	

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

140

\*140\*

Quality Control

MLJ 14-02-26
MF 14-2-26

DQA:			Date:									TRACT	
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
Work Orde	or.					DISPOSITION			AGAINS	T DE	PARTMENT	PROCESS	
WOIK OIG	-'' -				—	Rework	1		Skid-tube Crosstube	<u>.</u> [	1	Water Jet	Engineering
Part N	۱o.					Scrap	1		Machining Small Fal	_	Pro	d. Eng. Coor.	Quality
	-					Use-as-is	1		noforming Finishin	g	Rec/Stor	e/Packaging	Other
NCR I	No.					Suspected Unapproved		٠	Large Fab Composite	e 🗌	]	Supplier	
Root					Desc	ription of work order update		nitial	Action		Sign &	<del></del>	
Cause	ļ	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling					~								
Handling/Pre					1		İ						
Material													
Operator													
Offset/Setup											i		
Process	Ш						1						
Supplier													
Training													
Transport													
Unapproved					}								
							FA	ULT CA	TEGORY				
Landi	ng (	Gear			_	General		n .		_	7	<b>_</b>	<b>-</b>
		Bending			<u> </u>	Bend	<u> </u>	1	Program	$\vdash$	Outside Dim	<b>-</b>	Pressure/Forced
	<u> </u>	Centre No	ot Concer	ntric		BOM/Route	<b>L</b>	Grain			Over/Under	<del> </del>	Set-up
	<u> </u>	Cracks			<u> </u>	Broken/Damage/Defect	$\vdash$	Hardwa		$\perp$	Part Incorre		Temperature/Cure
	L	Crimp/Kii	nk/Ripple	:/Wave	_	Burrs	lacksquare	4 ·	tion Incomplete/Unqualified	L	Part Lost/M	issing	Weld
	L	Cuffs				Contamination		-	tions Incomplete/Unclear	_	Part Moved	L	Wrong Stock Pulled
		Crushing			<u> </u>	Countersink	$\vdash$	-	gned/off center	$\vdash$	Positioned V	_	¬₋.
		Heat Trea				Cut Too Short	<u></u>	Mislab			Power Loss/	Surge	Other
	$\vdash$	Inspectio	n Strip in	Tube		Drawing		Misrea				<del></del>	
		Marks/Cl			<u> </u>	Drill Holes		Off-set					
		Turning S				Finish	$\perp$	-	Calibration				
			Fit/Function		Out of	Sequence							

Required Date: 1/07/14

Required Qty: 8.00

**Start Date:** 1/07/14

Start Qty: 8.00

January-07-14 3:01:04 PM

Work Order ID:

110702

Parent Item:

**Comments:** 

D3459-3

Parent Item Name:

Float Step Mounting Plate

IPP Rev: A New Issue 06-01-06 JLM

IPP Rev: B waterjet 06-12-06 ec

	HI ROW B Water	00 12 00							· · · · · · · · · · · · · · · · · · ·			
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
M6061T6B0.187X04.000	)	Purchased	No			110	f	11.0500	0.347	2.9 <del>22103</del>	б . О	JM14.02-74

<b>Location</b>	Loc Qty	Loc Code	
MAT051	11.05		
123279	10		
125590	1.05		163590

DQA:			Date:											•	
						WORK ORDER NON	-CC	ONFO	RMANCE / U	PDATE					AEROSPACE
QA Closed:			Date:								Wo	rk Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST	DEF	PARTMENT	PROCESS		
	-				_	Rework			Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.		Quality
	•		••			Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Desc	I ription of work order update		nitial	Ac	tion		Sign &			
Cause		Date	Step	Qty	2000	or non-conformance		ief Eng		ription	ŀ	Date	Verification		QC Inspector
Design			•							•				┪	
Doc/Data											ļ				
Equip/Tooling															
Handling/Pre							١								
Material							l				١			1	
Operator				<b>}</b>											
Offset/Setup				`							İ				
Process															
Supplier	Щ														
Training	_														
Transport						,									
Unapproved			<u> </u>				J								
							FA	ULT CAT	TEGORY			<u> </u>			
Landir						General		1 /_	_				. г		
		Bending			<u> </u>	Bend	$\vdash$	1	Program		$\vdash$	Outside Dim	<b>⊢</b>		Pressure/Forced
		Centre No	ot Concer	ntric	-	BOM/Route	$\vdash$	Grain			$\boldsymbol{\vdash}$	Over/Under			Set-up
		Cracks	-1. /p:1-	. 644	-	Broken/Damage/Defect	$\vdash$	Hardwa			$\vdash$	Part Incorred			Temperature/Cure Weld
1		Crimp/Kir	ік/кірріе	ywave	$\vdash$	Burrs	$\vdash$	1 '	ion Incomplete/U	•	$\vdash$	Part Lost/Mi	· -	_	
		Crushing			<u> </u>	Contamination Countersink	$\vdash$	4	tions Incomplete/ gned/off center		Н	Part Moved Positioned V			Wrong Stock Pulled
		Crushing Heat Trea	<b>^</b>		$\vdash$	Cut Too Short	$\vdash$	Mislabe			-	Power Loss/	· · ·		Other
		Inspectio		Tube	-	Drawing	$\vdash$	Misrea			ш	1 04401 2033/			100101
	$\vdash$	Marks/Ch		IUDE	$\vdash$	Drill Holes	$\vdash$	Off-set							•
	<del> </del>	Turning S				Finish	-	4	Calibration						
	$\vdash$	Wave/Tw			<u> </u>	Fit/Function		4	Sequence		•				

DART AEROSPACE LTD	Work Order:	110702
Description: Float Step Mounting Plate	Part Number:	D3459-3
Inspection Dwg: D3459 Rev: A		Page 1 of 1

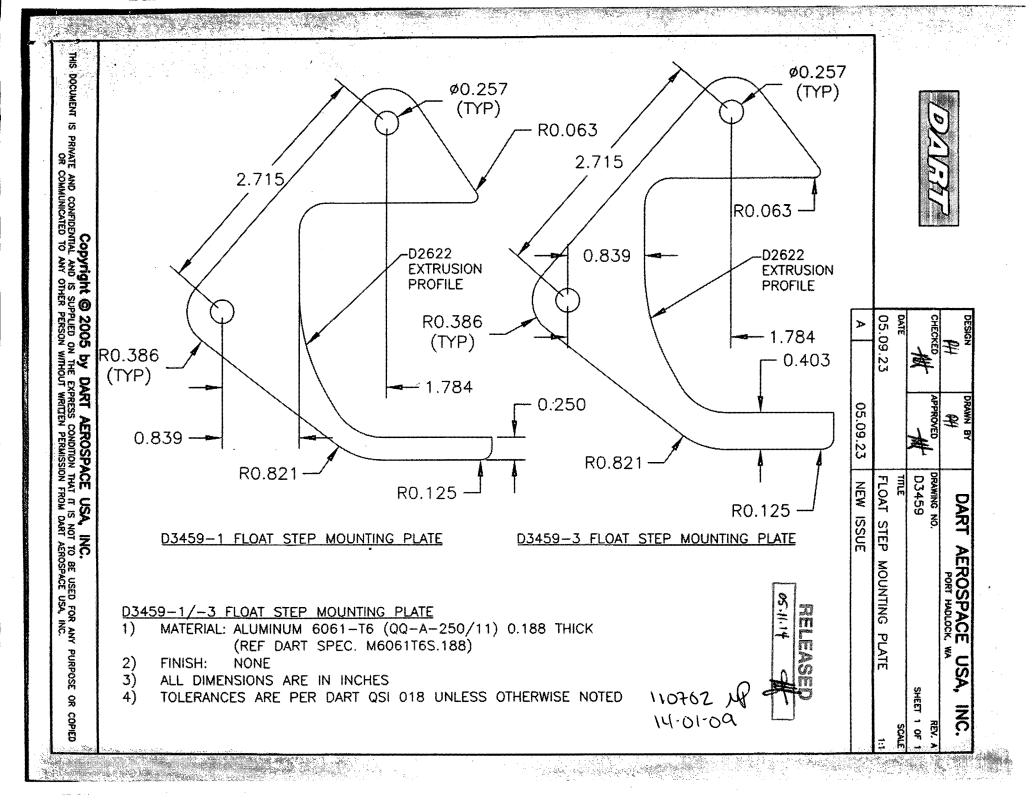
## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	0259			V	Thuo,
2.715	+/-0.010	2.715	_		V	
0.403	+/-0.010	6,403	-	102	ν	
R0.125	+/-0.010	0.125"	_		RG- RG	
R0.063	+/-0.010	0.063			Ro	
0.839	+/-0.010	O. 839°	1		<b>&gt;</b>	
0.188	+/-0.010	0.187"				
					•	
2.0						
			DAS			

Measured by:	Juj	Audited by:	9-58 }	Prototype Approval:	N/A
Date:	14-02-26	Date:	14/2/26	Date:	N/A

A 07.01.17 New Issue KJ/JLM B 07.09.06 Dimensions added KJ/JLM	Rev	Date	Change	Revised by	Approved
B 07.09.06 Dimensions added KJ/JLM	Α	07.01.17	New Issue	KJ/JLM ,	
	В	07.09.06	Dimensions added	KJ/JLM ox	E



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